TapirTapes
QUALITY CONNECTS

DATASHEET

IGUNA CL10

Product Discription

IGUNA CL10 is a double sided high performance acrylic based adhesive tape. This conformable tape is especially designed for the bonding of transparent materials like glass, PMMA and PC. It also is capable of absorbing the different thermal expansions of two materials. This acrylic foam tape has a very high transparency. In combination with a primer this IGUNA Tape family guarantees excellent adhesion performance even on medium and low surface energy substrates.

Technische Daten / Technical Data

Thickness mm:	1 mm
Adhesive base:	Closed cell acrylic
Liner	Red PE liner or Siliconised Paper liner
Density	900 kg/m³ (56lb/ft³)
90° peel adhesion N/10 (lb/in)	33 (19)
Dynamic Shear Strength kPa (lb/in²)	520 (75)
Normal Tensile kPa (lb/in²)	590 (86)
Static Shear Strength g/312mm² (7days)	22°C - 1000 66°C - 500 93°C - 500 121°C - 177°C -
Temperature resistance Minimum Temperature resistance Short term Temperature resistance Long term	-40°C 160°C 100°C
Colour:	Transparent
Core diameter mm:	76
Storage life – 18°C / 55%RF:	24 Monate / 24 months
Suitable for	High and medium surface energy plastics, transparent plastics, stainless steel, galvanized steel, anodized aluminum, coated aluminum, glass*

Surface

Tape bonding is one of the most variable and easy technology mating substrates. Especially for assemblies made of different substrates having different thermal expansion rates bonding is an easy method for a long term durable joint. IGUNA Tapes allow a high variation in such substrates as all are available in different thickness. To ensure proper performance of such bonded part follow the following recommendations.

Design

A proper tape bond design means avoiding cleavage and peel forces. Design leading to pure shear and tensile loads have to be preferred to utilize full IGUNA Tapes performance.

Surface Preperation

All bonding process require proper surface preparation / cleaning. This will enable IGUNA Tapes to get in direct contact with the surface creating full adhesion force. IGUNA Surface Cleaner will remove most (polar) contaminations such as fingerprints and light oil. IGUNA Strong Surface Cleaner is used for more non-polar contaminations as grease or mould release agents. Check suitable cleaner with surface test inks. Use lint free tissues for such operations.

Surface Modification

If simple cleaning cannot achieve appropriate adhesion forces the following surface modifications can be uses. For larger scale process operations the use of e.g. flame activation can be used. On smaller scale / repair operations the use of a Primer might be a solution. All Primer / activators should only be used on the area for bonding. Excess material has to be cleaned immediately.

Temperature

After proper surface preparation / modification IGUNA Tapes should be applied at a temperature level above 18°C. For temperatures below this but above 0°C use IGUNA low temperature Tapes.

Pressure

Ensure immediate part of assembly after liner removal. Pressure should be applied in rolling fashion at approx. 10N/cm². Recommended roller speed at 10 mm/s (24in./min.) Higher velocities might require higher pressure or control with surface pressure films. IGUNA Tapes achieve their full strength after 72h at ambient temperature. Higher temperatures can accelerate strength development.

Storage & Shelf Life

Store IGUNA Tapes between 5°C and 35°C. Humid condition causing condensation should be avoided. For products with non-siliconized liners shelf life is 24 months; products with siliconized liners and Splice/Tabbing tapes shelf life is at 12 months.

Disclaimer

All technical data in this product data sheet are based on Tapir Tapes experience and external testing institutes. These values are representative for the overall performance. These data sheets are NOT to be used for specification purposes or for your own specific application. It is your responsibility to test whether the tape is suitable for your application or project. Tapir Tapes will NOT be held liable for any information provided on this data sheet. Please follow the rules and regulation that are applicable in the state, country or country where the Tapir Tapes are being used. If you have any questions regarding the use of the IGUNA Tapes acrylic foam tapes, please contact your local sales team. For questions on the standard warranty, please review our terms and conditions. For all other warranties, please review all documents that should have been agreed to in writing prior to the sale between Tapir Tapes and the customer. IGUNA is a brand of Tapir Tapes.